

# Work Order ID 72789

Friday, August 12, 2011 2:39:48 PM



Page 1

Item ID: D206-628-012

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step RH

Start Date: 8/12/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 8/19/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

11-08-10

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

N/A

Rev N/A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels as per PPP D206-628-012 CHG 003

8/11/10/26

P10 →

For MLS 11-10-25

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

SP 11-10-24

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

Quality Control

8/11/10/26

(x2)

R24

72790.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D201-628-012 PAR #: ✓/r Fault Category: Production/Eng NCR: Yes No DQA: ✓ Date: 11.10.28  
11-936 Resolution: Re-work Disposition: rework QA: N/C Closed Date: 11/10/31

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/10/25	#100	incorrect parts on w/o side list to FZN. RC LOA when create w/o + Bom	UP 11.10.27 BS/lyz	Remove incorrect parts from kit D3354-041 + D0731-2	ES 11.10.27	S 11/10/28	UP 11.10.27 BS/lyz	S 11/10/25
			UP 11.10.27	correct w/o + Bom ADD copy of Bom & as Ref	11.10.27	EE	UP 11.10.27	S 11/10/25

NOTE: Date & initial all entries

**Work Order ID 72789**

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Item ID: D206-628-012

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step RH

Start Date: 8/12/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 8/19/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-628-012 □ Location: <u>F1</u> □ PPP Rev: <u>F</u>								
140 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

SP 11-10-26 2.0

11/10/26 MF 11-10-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 72789

Parent Item: D206-628-012

Parent Item Name: Heli-Access-Step RH

Start Date: 8/12/2011


Required Date: 8/19/2011

Start Qty: 2.00


Required Qty: 2.00

Comments: IPP Rev:D As Per Ecn 766 06-01-06 JLM  
 IPP rev E changed D2731-1 to D2731-3 EC  
 IPP Rev:F as per ecn 1118 08-02-05 DD verified by:


Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4-13A		Purchased	No			120	Each	1,124.000	4	8			
													
Bolt													


Location	Loc Qty	Loc Code
ST357	1124	
117962	4	
118078	594	
118350	226	
118351	300	

AN4-14A		Purchased	No			120	Each	121.0000	4	8			
													
Bolt													

Location	Loc Qty	Loc Code
ST357	121	
117872	21	
118451	100	

AN4-15A		Purchased	No			120	Each	127.0000	4	8			
													
Bolt													

Location	Loc Qty	Loc Code
ST357	27	
117423	27	
ST358	100	
118112	100	

AN960JD416	NAS1149D0463J	Purchased	No			120	Each	0.0000	12	24			
													
Washer													

m118704e. SP

m118704 SP

m118648 SP

m119042  
SP 11-10-24.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 72789

Parent Item: D206-628-012

Parent Item Name: Heli-Access-Step RH

Start Date: 8/12/2011

Required Date: 8/19/2011

Start Qty: 2.00

Required Qty: 2.00

D2721-042

Manufactured No

120

Each

0.0000



206B Step Assembly

D2731-3

Manufactured No

120

Each

60.0000



Mounting Lug

Location

Loc Qty

Loc Code

ST469

60

47967

37

52329

23

Manufactured No

120

Each

77.0000



Mounting Lug

Location

Loc Qty

Loc Code

ST468A

50

71860

50

ST470

27

62929

3

66427

24

Manufactured No

120

Each

6.0000

D2732-030



Rubber Cushion

Location

Loc Qty

Loc Code

ST402

6

69205

6

S+2  
Qty + 8 per kit  
@ 3.00  
7 more kits  
8/10/12

1 2



BZ0798

2 4



SP

1 4



4X

1 4



4X

8 16



B73759  
SP 11-10-24

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

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Work Order ID: 72789

Parent Item: D206-628-012

Parent Item Name: Heli-Access-Step RH

Start Date: 8/12/2011

Required Date: 8/19/2011

Start Qty: 2.00

Required Qty: 2.00

D3394-041

Manufactured No

120 Each

26.0000

2

4



Lug Assembly



B73418-4x  
SP

Location

Loc Qty

Loc Code

ST

3

ST474

26

68257

26

D3394-043

Manufactured No

120 Each

49.0000

2

4



Lug Assembly



SP

Location

Loc Qty

Loc Code

ST475

49

62930

2

62976

14

66429

33

MS21042L4

Purchased No

120 Each

4,817.000

12

24



Nut



SP 11-10-24

Location

Loc Qty

Loc Code

ST300

4817

117441

672

117601

645

117885

1500

118451

2000

24x

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Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

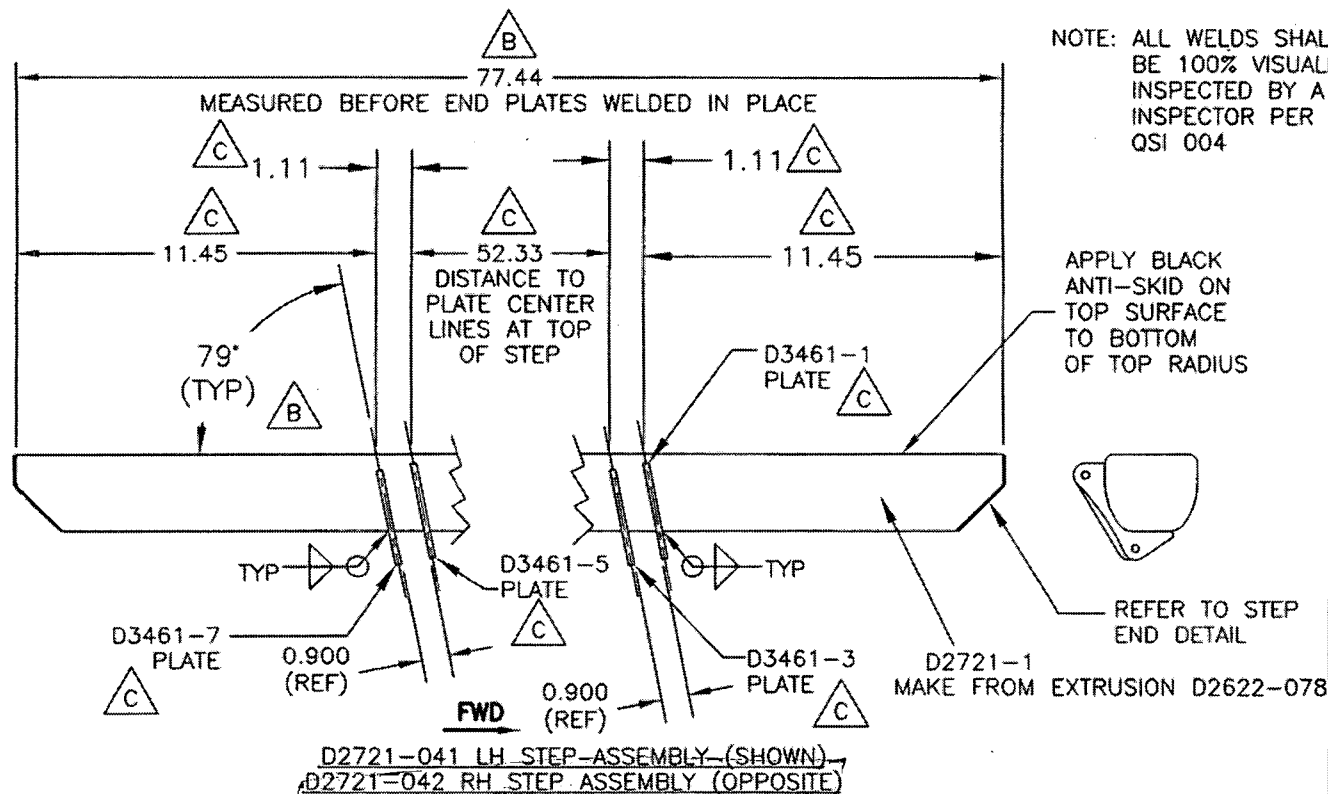
### 5.1 D206-628-011/-012/-021/-022/-031/-032 REGULAR DART HELI-ACCESS- STEPS™ PARTS LIST

Qty -011	Qty -012	Qty -021	Qty -022	Qty -031	Qty -032	Part Number	Description
X						D206-628-011	206 A/B STEP INSTALLATION LH
	X					D206-628-012	206 A/B STEP INSTALLATION RH
		X				D206-628-021	206 L/L1/L3/L4 STEP INSTALLATION LH
			X			D206-628-022	206 L/L1/L3/L4 STEP INSTALLATION RH
				X		D206-628-031	407 STEP INSTALLATION LH
					X	D206-628-032	407 STEP INSTALLATION RH
1						D2721-041	STEP ASSEMBLY LH
	1					D2721-042	STEP ASSEMBLY RH
		1		1		D2724-041	STEP ASSEMBLY LH
			1		1	D2724-042	STEP ASSEMBLY RH
				4	4	D2731-3	MOUNTING LUG
4	4	4	4	4	4	D2731-7	MOUNTING LUG
8	8	8	8	8	8	D2732-030	RUBBER CUSHION
				4	4	D3394-041	MOUNTING LUG
				4	4	*D3394-1	*MOUNTING LUG
				8	8	*MS35489-93	*GROMMET
4	4	4	4			D3394-043	MOUNTING LUG
4	4	4	4			*D3394-3	*MOUNTING LUG
8	8	8	8			*MS35489-93	*GROMMET
4	4			4	4	AN4-13A	BOLT
4	4	4	4	4	4	AN4-14A	BOLT
4	4	8	8	4	4	AN4-15A	BOLT
12	12	12	12	12	12	NAS1149D0463J	WASHER (AN960JD416)
12	12	12	12	12	12	MS21042L4	NUT (OR MS21042-4)

\*DENOTES THAT PART IS INCLUDED IN ASSEMBLY ABOVE

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NOTE: ALL WELDS SHALL  
BE 100% VISUALLY  
INSPECTED BY A QUALIFIED  
INSPECTOR PER DART  
QSI 004

APPLY BLACK  
ANTI-SKID ON  
- TOP SURFACE  
TO BOTTOM  
OF TOP RADIUS

- REFER TO STEP  
END DETAIL

D2721-1  
MAKE FROM EXTRUSION D2622-078

D2721-041 LH STEP-ASSEMBLY-(SHOWN)-  
D2721-042 RH STEP ASSEMBLY (OPPOSITE)

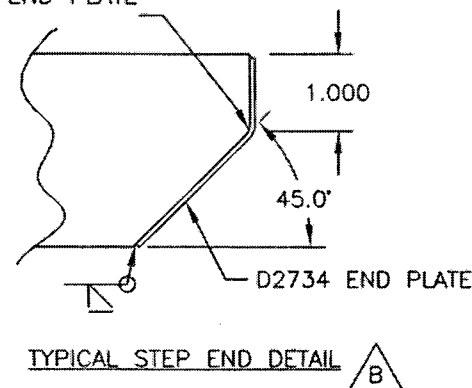
ROUND CORNER OF EXTRUSION TO  
MATCH BEND RADIUS OF END PLATE

**D2721-041/-042 STEP ASSEMBLY PARTS LIST**

QTY - 041	QTY - 042	PART NUMBER	DESCRIPTION
X		D2721-041	LH STEP ASSEMBLY
	X	D2721-042	RH STEP ASSEMBLY
1	1	D2622-078	EXTRUSION
2	2	D2734	END PLATE
1	1	D3461-1	PLATE
1	1	D3461-3	PLATE
1	1	D3461-5	PLATE
1	1	D3461-7	PLATE

D2721-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED





TYPICAL STEP END DETAIL

RELEASED  
05.11.14

REFERENCE ONLY

# DAFT

DESIGN	DRAWN BY		DART AEROSPACE USA, INC.	
PH	PH		PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. C	
		D2721	SHEET 1 OF 1	
DATE	TITLE		SCALE	
05.09.19	206B STEP ASSEMBLY		NTS	
A	97.12.04	NEW ISSUE		
B	98.10.19	79" WAS 80", UPDATED WELD DETAIL. REVISED TOLERANCES, 53.44 WAS 54.0		
C	05.09.19	RE-DESIGN, ADD D3461-1/-3/-5/-7		